



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-145
Job Sheet 167078-D



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 10/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 <u>5022249</u>	1 <u>5022248</u>	3	0	0
	D4636-5 <u>5022248</u>	1	43	0	0
	D4647-1 <u>5022247</u>	1	4	0	0
	D4664-5 <u>5022246</u>	6	39	0	0
	D4712-1 <u>5022243</u>	1	4	0	0
	D4732-17 <u>5007456</u>	1	0	0	0
	D4732-23 <u>5022241</u>	1	1	0	0
	D4732-27 <u>5022239</u>	1	1	0	0
	D5021-5 <u>5022237</u>	1	1	0	0
	MPNY-750S-9-C <u>5022236</u>	9	570	0	0
	MS20426AD3-4 <u>5022234</u>	4	5,055	0	0
	MS20426AD4-6 <u>5022232</u>	2	2,797	0	0
	MS21059L08 <u>5022231</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description V _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																				
 S022943 Aft, Center Ceiling Replacement Panel Assembly PART NO: D4634 – 145 Revision: Operation: Start up Operation Change No: Mfg Date: 12/15/17 Job No: 167078 – D																																																						
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